

# Work Order ID 72507

Wednesday, July 27, 2011 11:47:24 AM

Page 1

Item ID: D2362-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Support Bracket

Start Date: 7/27/2011

Start Qty: 6.00

Cust Item ID:

Required Date: 8/2/2011

Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2362

Rev E1

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA800 Rev: AA & Dwg D2362 Rev: E □2-Deburr  
per dwg D2362

B.A 11/08/02

12

φ

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B.A 11/08/02

12

φ

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

ant 11/08/03

12

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D2362-3	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Support Bracket					
Start Date: 7/27/2011	Start Qty: 6.00		Cust Item ID:		
Required Date: 8/2/2011	Req'd Qty: 6.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00				12	0		
Small Fab	Deburr								
140 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00				12	0		
Powder Coating	START TIME: 9:00am								
	FINISH TIME: 9:30am								
	OVEN TEMPERATURE: 320°F								
150 	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

12X0 m-11/08/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Work Order ID 72507

Wednesday, July 27, 2011 11:47:24 AM



Page 3

Item ID: D2362-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Bracket

Start Date: 7/27/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Bond rubber D2397-1 followed by D2397-3 using contact cement <input type="checkbox"/> as per Dwg D2362 Batch <u>M111090</u>								
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
180 	Identify as per dwg & Stock Location: <u>984</u>	0.00							
Packaging	Memo	0.00							
Packaging									

*EP 5/11/08/11* (12)

*5/11/08/11*

(12)

*6/11/12* (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 72507**

Wednesday, July 27, 2011 11:47:24 AM



Page 4

Item ID: D2362-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Bracket

Start Date: 7/27/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/08/12

11-08-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, July 27, 2011 11:47:30 AM

Page 1

Work Order ID: 72507

Parent Item: D2362-3

Parent Item Name: Support Bracket



Start Date: 7/27/2011

Required Date: 8/2/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: G000.05.18 Added inspection level 8 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2397-3  Rubber Cushion		Manufactured	No			100	Each	1.0000	1	6			
<div> <div>Location</div> <div>GA</div> <div>69319</div> </div> <div> <div>Loc Qty</div> <div>1</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
D2265  Step Bracket		Manufactured	No			160	Each	91.0000	1	6			
<div> <div>Location</div> <div>ST482</div> <div>37477</div> <div>✓ 44114</div> </div> <div> <div>Loc Qty</div> <div>91</div> <div>9</div> <div>82</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
D2397-1  Rubber Cushion		Manufactured	No			160	Each	2.0000	1	6			
<div> <div>Location</div> <div>GA</div> <div>69321</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> </div>													

*EP 11/08/11*  
B72736  
(11X)

GA 11/08/02

12.0  
*EP 11/08/11*  
2  
B72737  
(10X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	72507
<b>Description:</b> Step Support Bracket		<b>Part Number:</b>	D2362-3
<b>Inspection Dwg:</b> D2362	<b>Rev:</b> E1	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.005 -0.000	Ø0.259	✓		VERN	GA-01
3.074	+/-0.010	3.075	✓		"	"
0.34	+/-0.030	0.339	✓		"	"
0.77	+/-0.030	0.790	✓		"	"
1.500	+/-0.010	1.500	✓		"	"
1.000	+/-0.010	1.002	✓		"	"
0.80	+/-0.030	0.781	✓		"	"
1.200	+/-0.010	1.203	✓		"	"
1.28	+/-0.030	1.273	✓		"	"
1.000	+/-0.010	1.009	✓		"	"
0.75	+/-0.030	0.758	✓		"	"
1.88	+/-0.030	1.880	✓		"	"

<b>Measured by:</b> B.A	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11/08/02	<b>Date:</b> 11/08/03	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF [Signature]	[Signature]

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

NO. 22507



44-17-27

RELEASED  
98.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
BW	CP		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 3
KE	CP	D2362	
DATE	TITLE	SCALE	
98.12.04	STEP SUPPORT BRACKET	1:2	
A	95.02.15	NEW ISSUE	
B	95.03.22	CHANGED RUBBER TO D2397	
C	96.01.22	ADD D2362-5	
D	97.05.21	ADD D2362-7	
E	98.12.04	REDRAWN, ADD 2397-5	

UNDER REVIEW

03.03.15 CP

DESIGN OK, BUT CHECK WITH  
DTS BEFORE MANUFACTURE  
OK 04/11/04

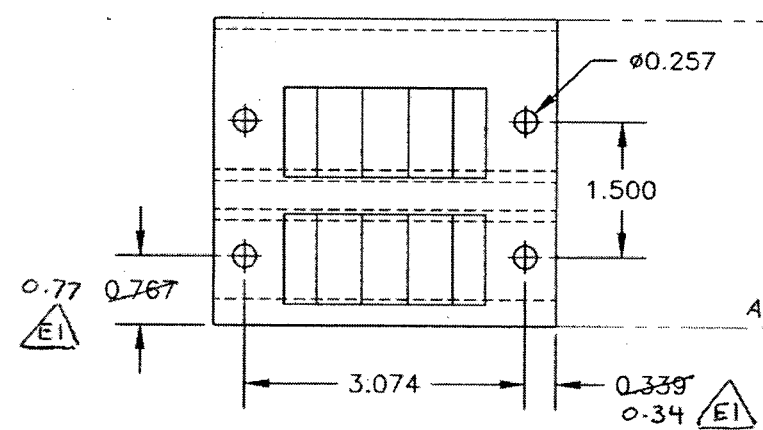
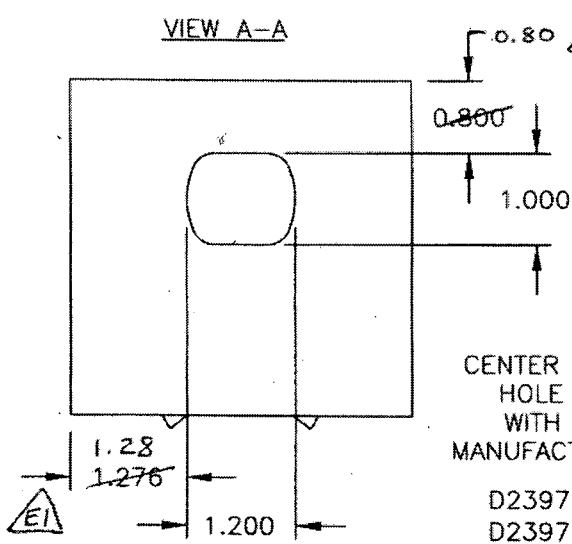
REMOVE TIPS  
FROM CASTING  
MAX 0.080

CENTER D2397-1/-3 RUBBER  
HOLE WITH SLOT AND BOND  
WITH CONTACT CEMENT PER  
MANUFACTURER'S SPECIFICATION

D2397-1 RUBBER CUSHION (1)  
D2397-3 RUBBER CUSHION (1)

D2362-3

EI 03.10.07 TOLERANCE CHANGE RT



0.257 X 0.75 SLOT

NOTES:

MAKE FROM D2265

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING  
RUBBER IN PLACE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

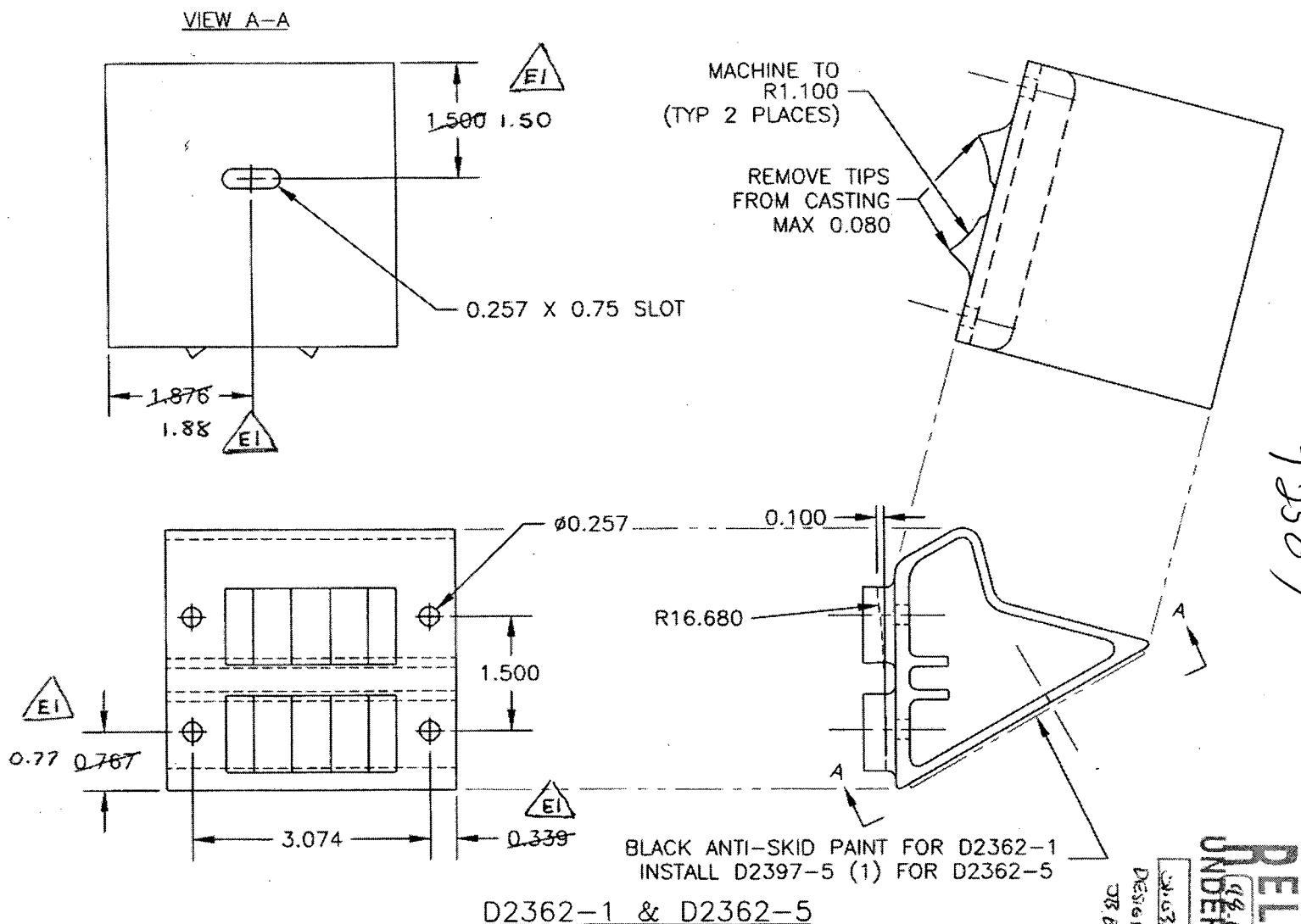
QA COPY ISSUED

DESIGN	DRAWING BY		DARI AEROSPACE LTD	
BW			HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E	
<i>KE</i>	<i>SH</i>	D2362	SHEET 2 OF 3	
DATE	TITLE		SCALE	
98.12.04	STEP SUPPORT BRACKET		1:2	

RELEASED  
198.12.14  
UNDER REVIEW

DESIGNER, BUT EFFECT BY  
J.B. BETHUNE MANUFACTURE

OK  
P. H. H.



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**



DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. E
CHECKED	KE	APPROVED	MA	DRAWING NO. D2362	SHEET 3 OF 3
DATE	98.12.04	TITLE	STEP SUPPORT BRACKET	SCALE	1:2

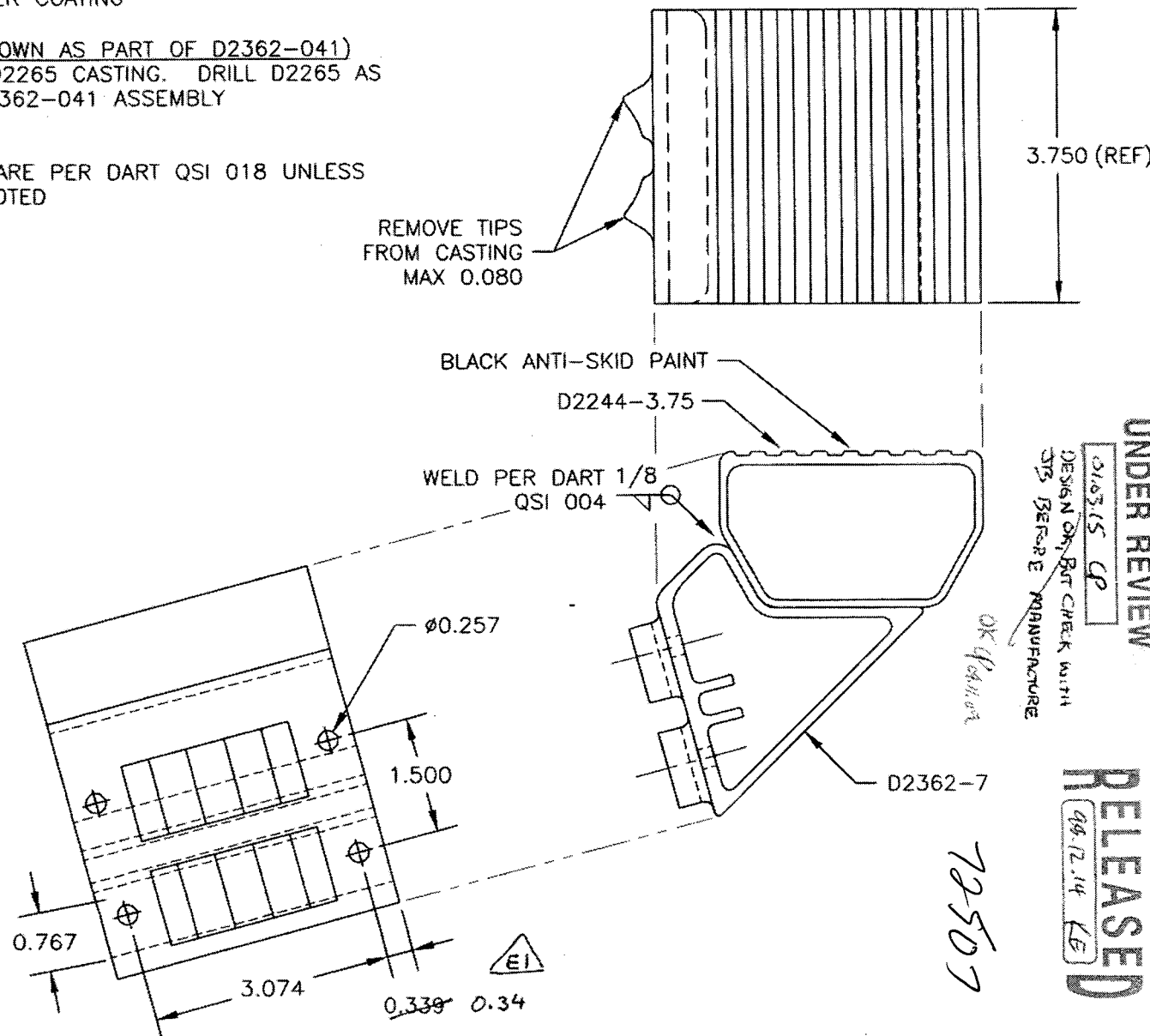
**UNDER REVIEW**

**RELEASED**  
98.12.14 KE

DESIGN OK BUT CHECK WITH  
MFG BEFORE MANUFACTURE

OK 12/14/04

72507



D2362-041 (SHOWN)  
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER  
QSI 005 4.3  
ANTI-SKID PAINT PER QSI 005 4.4 AFTER  
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)  
MAKE FROM D2265 CASTING. DRILL D2265 AS  
SHOWN IN D2362-041 ASSEMBLY

NOTES:  
TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries